

Work Order ID 109743

Wednesday, November 27, 2013 3:02:56 PM

109743

Page 1

Item ID: D3651-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Flange Weldment

Start Date: 11/27/2013 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/27/2013 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MF*Date: *12/1/27*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3651

Rev B

100

100

Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

Weld assembly as per dwg D3651

110

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

120

120

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

*already done
on w/o
94016
(also already
costed)*

109743

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 11/27/2013 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 11/27/2013 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Tooling:

Date:

Run Start *NR1*

SPC (Y/N):

Date:

Stop *NR2*

[illegible]

Work Order ID 109743

Wednesday, November 27, 2013 3:02:56 PM

109743

Page 3

Item ID: D3651-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Flange Weldment

Stop ***NS2***

Start Date: 11/27/2013 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/27/2013 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept Reject Reject Insp.
Qty Qty Number Stamp

160

QC21- Final Inspection - Work Order Release

0.00

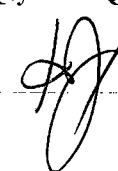
160

QC

Memo

0.00

Quality Control

 RM 13/12/30MRF
13-12-18

Picklist Print

Wednesday, November 27, 2013 3:02:55 P

Page 1 / 1

Work Order ID: 109743
Parent Item: D3651-043
Parent Item Name: Flange Weldment

Start Date: 11/27/2013

Required Date: 11/27/2013

Start Qty: 1.00

Required Qty: 1.00

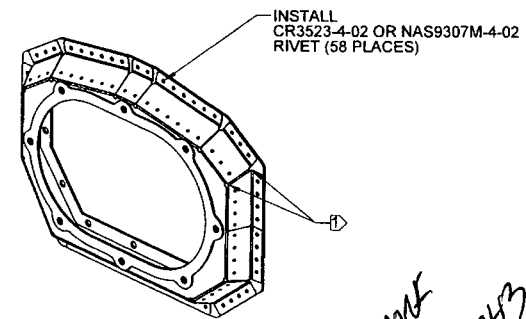
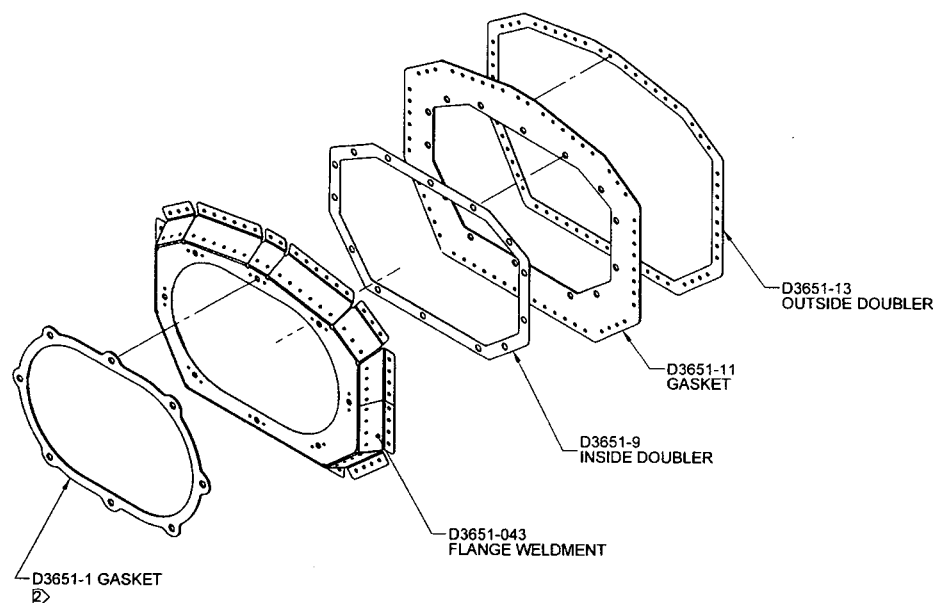
Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC
IPP Rev:B ECN 1113P 08-01-22 DD
IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3651-5 Top Flange		Manufactured	No			100	Each	0.0000	1	1			94648- MF 13-11-20
D3651-7 Bottom Flange		Manufactured	No			100	Each	0.0000	1	1			94589- already pulled 94016
CR3523-4-02 RIVET		Purchased	No			130	Each	500.0000	57	57			FF 13-12-17 pull 94016
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST330	500		57				
						m126826	500						
D3651-3 Base		Manufactured	No			130	Each	2.0000	1	1			FF 13-12-17
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						GA	2						
						108123	2		1				
MS20427M3-3 Rivet		Purchased	No			130	Each	1,185.0000	16	16			FF 13-12-17
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						GA	44						
						121114	44						
						ST335	1141						
						124231	1141						
MS21060-3K Nut/Plate		Purchased	No			130	Each	117.0000	8	8			FF 13-12-17
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST316	117						
						123168	4						
						124291	7						
						124486	6		1				
						m126826	100		7				

8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A



MF
109743
1371-24

PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3651-041	AFT BASE ASSEMBLY
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

08.01.07

D3651-041 AFT BASE ASSEMBLY

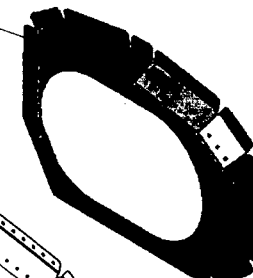
D3651-041 NOTES:

- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.6 lbs

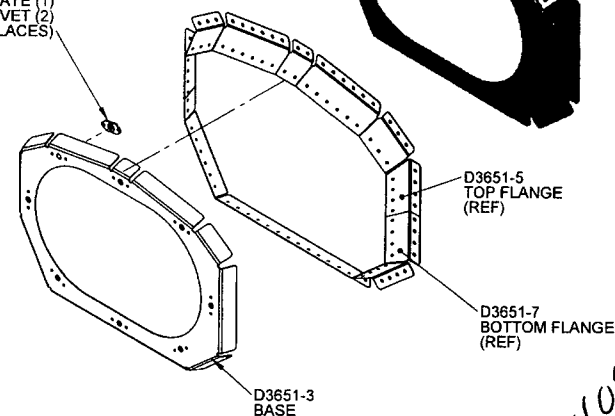
B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50; 0.88 WAS 0.98; REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>CE</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>MF</i>	D3651	SHEET 1 OF 9
APPROVED	<i>MF</i>	TITLE	SCALE
DE APPR.	<i>MF</i>	AFT BASE ASSEMBLY	
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT IT IS WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1

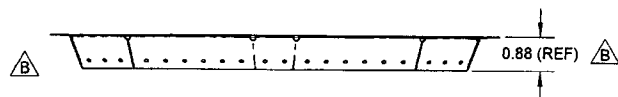
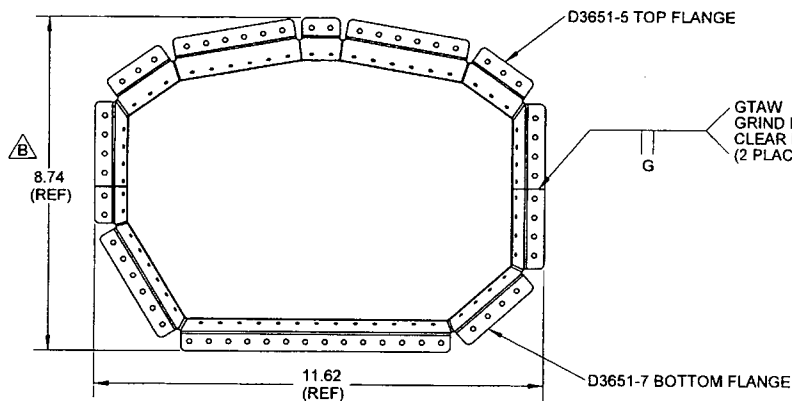
TRANSFER DRILL $\varnothing 0.129$ (#30 DRILL)
FROM D3651-5/-7 TO D3651-3
INSTALL CR3523-4-02 OR NAS9307M-4-02
RIVETS (57)



MS21060-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)



#109743



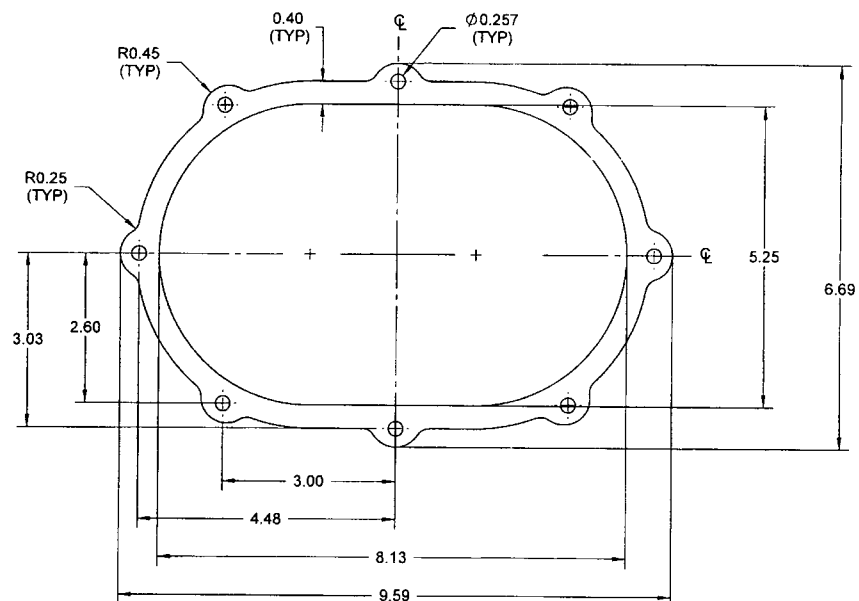
D3651-043 FLANGE WELDMENT

QTY -043	PART NUMBER	DESCRIPTION
X	D3651-043	FLANGE WELDMENT
1	D3651-3	BASE
1	D3651-5	TOP FLANGE
1	D3651-7	BOTTOM FLANGE
16	MS20427M3-3	RIVET
8	MS21060-3K	NUTPLATE
57	CR3523-4-02 or NAS9307M-4-02	RIVET

D3651-043 NOTES:

- 1) WELD PER QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.76 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	AS	D3651	SHEET 2 OF 9
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	AFT BASE ASSEMBLY	1:3
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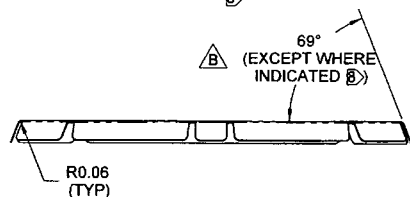
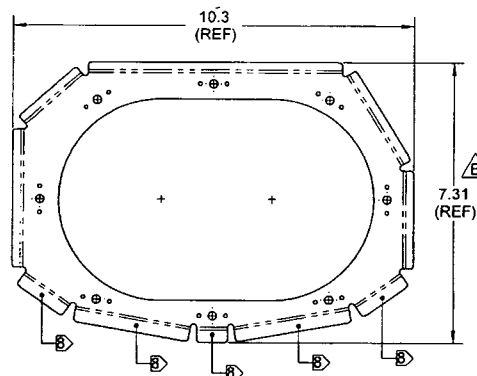
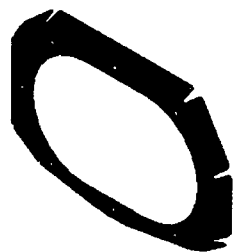


D3651-1 GASKET

NOTES:

- 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) PART IS SYMMETRIC ABOUT ϕ
- 8) WEIGHT: 0.09 lbs

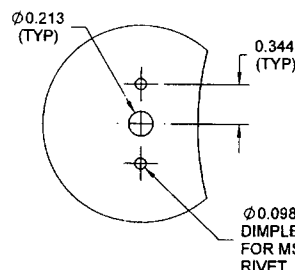
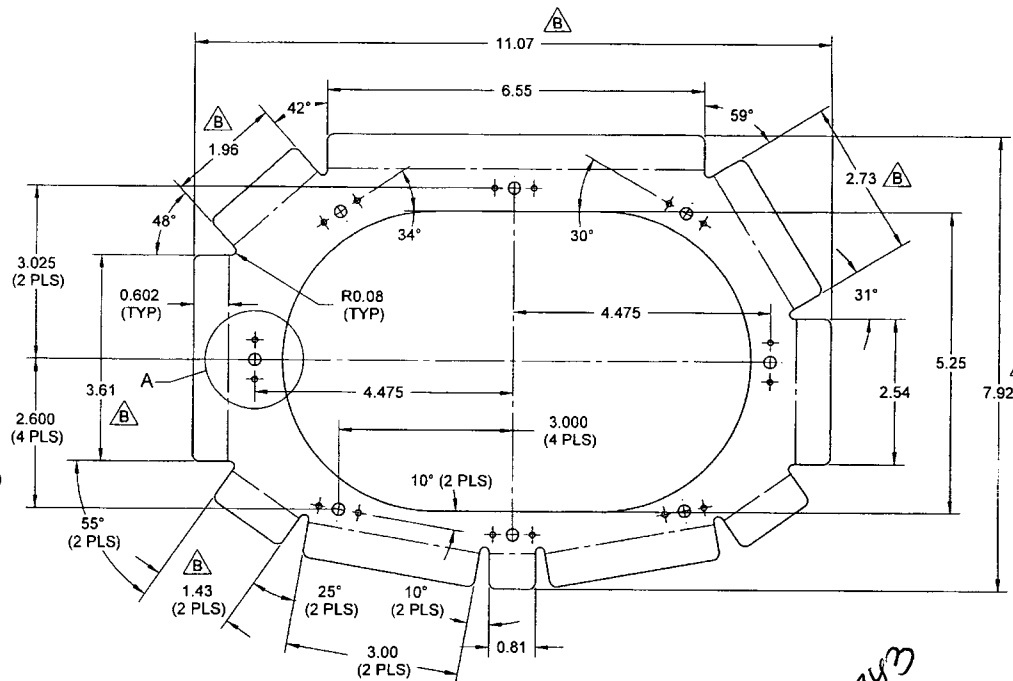
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3651	SHEET 3 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AFT BASE ASSEMBLY	1:2
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D3651-3 BASE
(MAKE FROM D3651-3F FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs
- 8) BEND TO 55° WHERE INDICATED



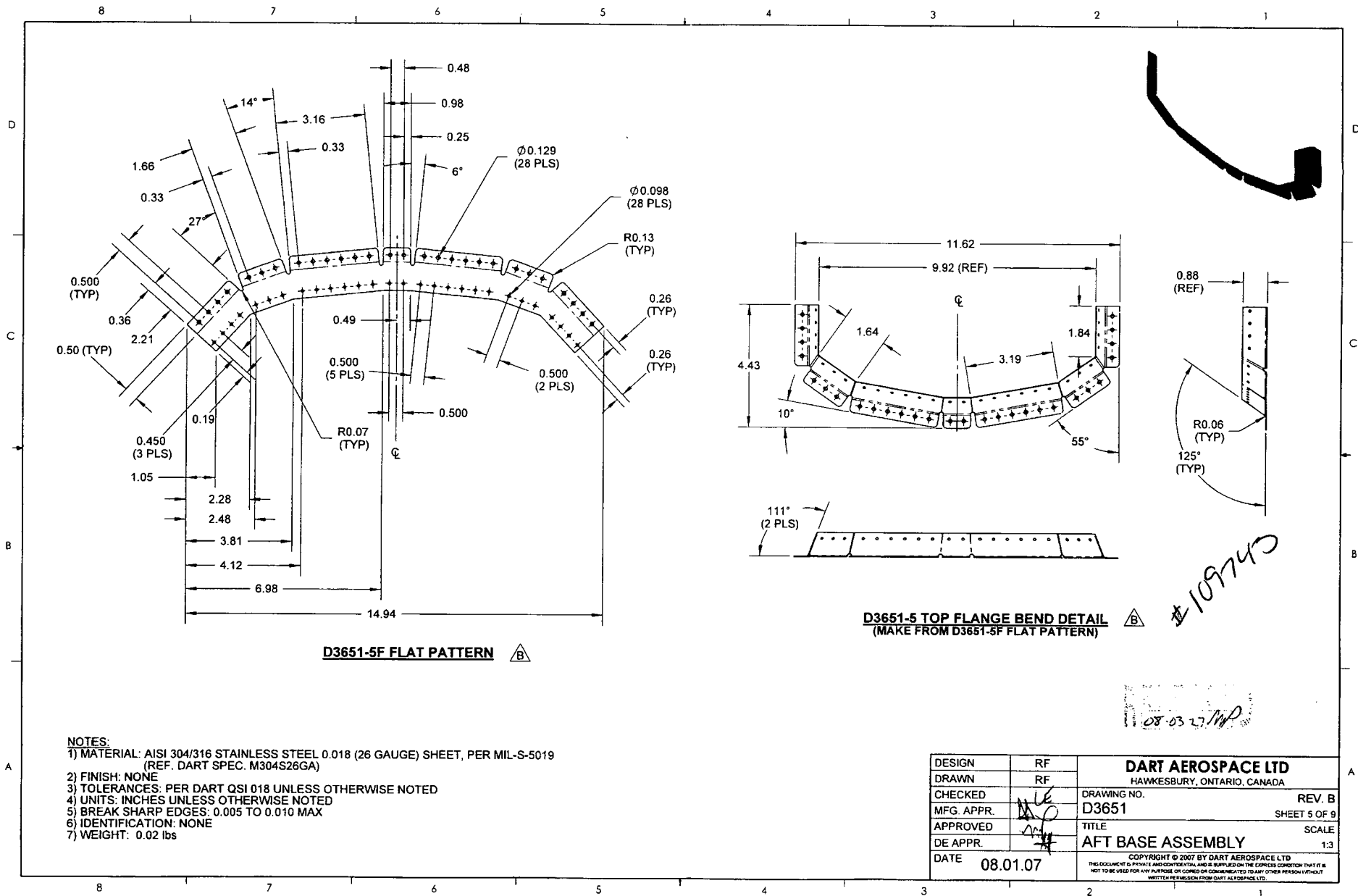
DETAIL A

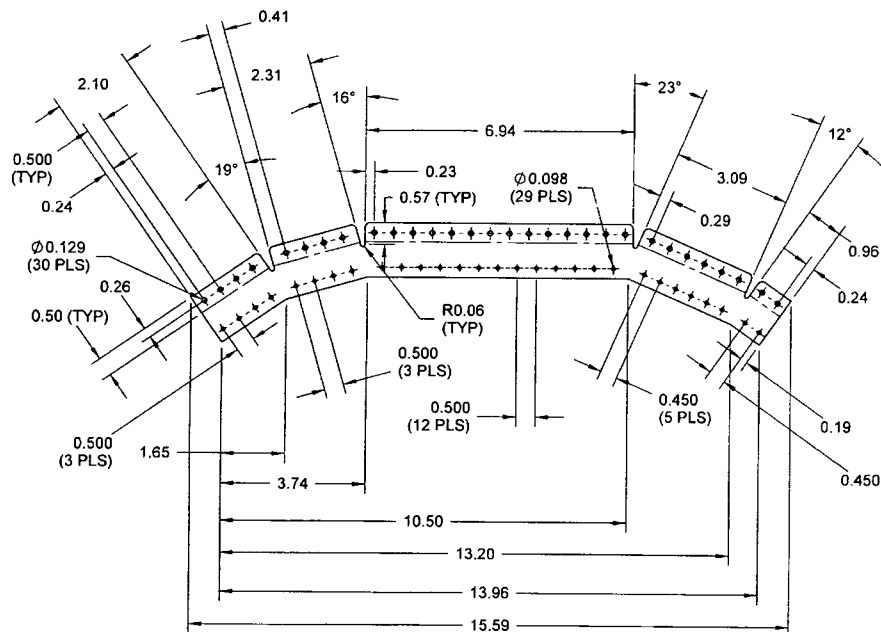
D3651-3F FLAT PATTERN

#109743

08-03-27-14

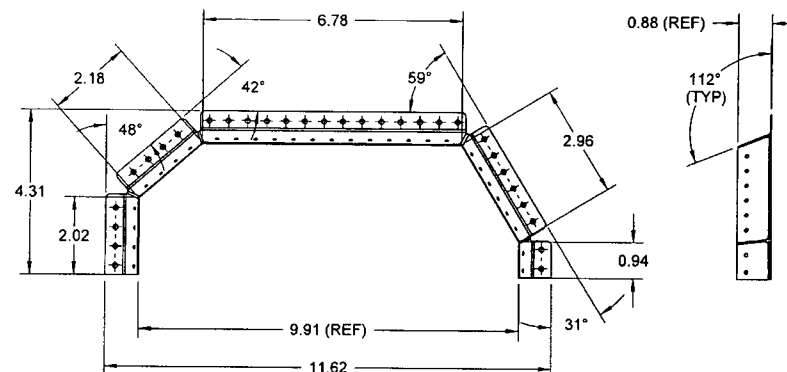
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	ME	D3651	SHEET 4 OF 9
APPROVED	ME	TITLE	SCALE
DE APPR.	ME	AFT BASE ASSEMBLY	1:2
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D3651-7F FLAT PATTERN

B



D3651-7 BOTTOM FLANGE BEND DETAIL
(MAKE FROM D3651-7F FLAT PATTERN)

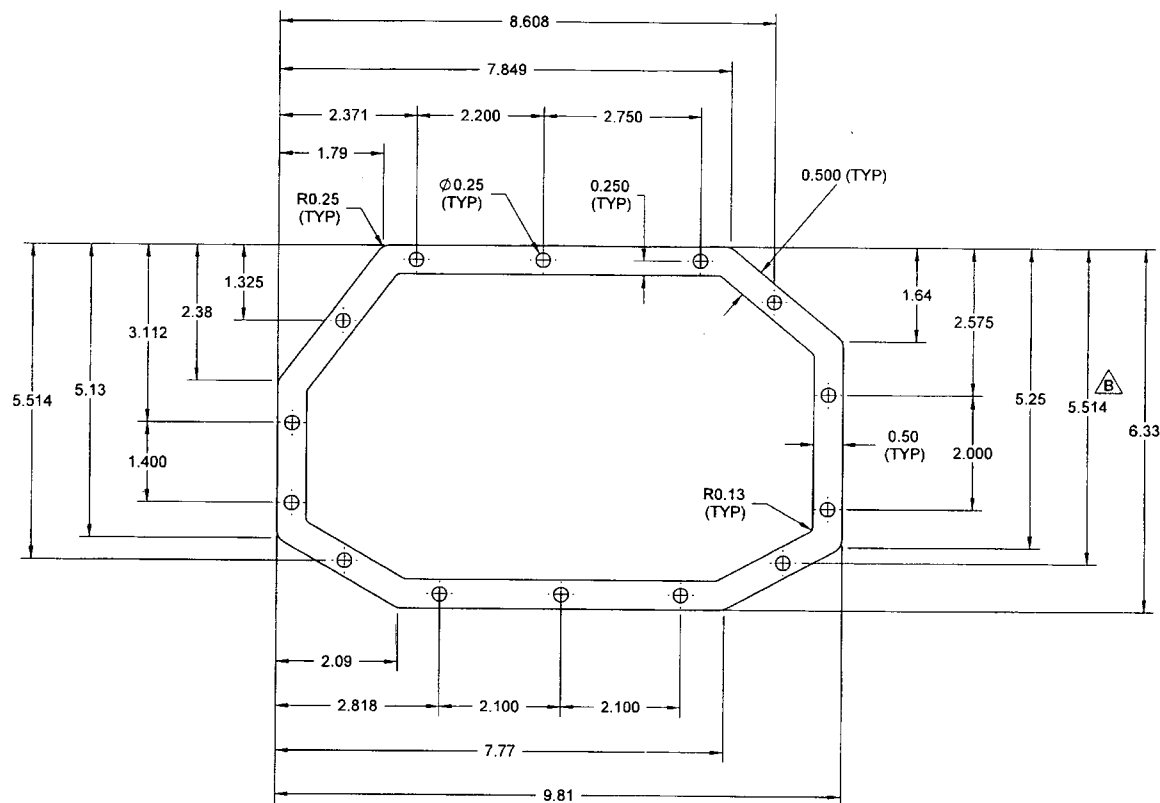
B

109743

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	DRAWING NO.	REV. B
MFG. APPR.	RF	D3651	SHEET 6 OF 9
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	AFT BASE ASSEMBLY	1:3
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

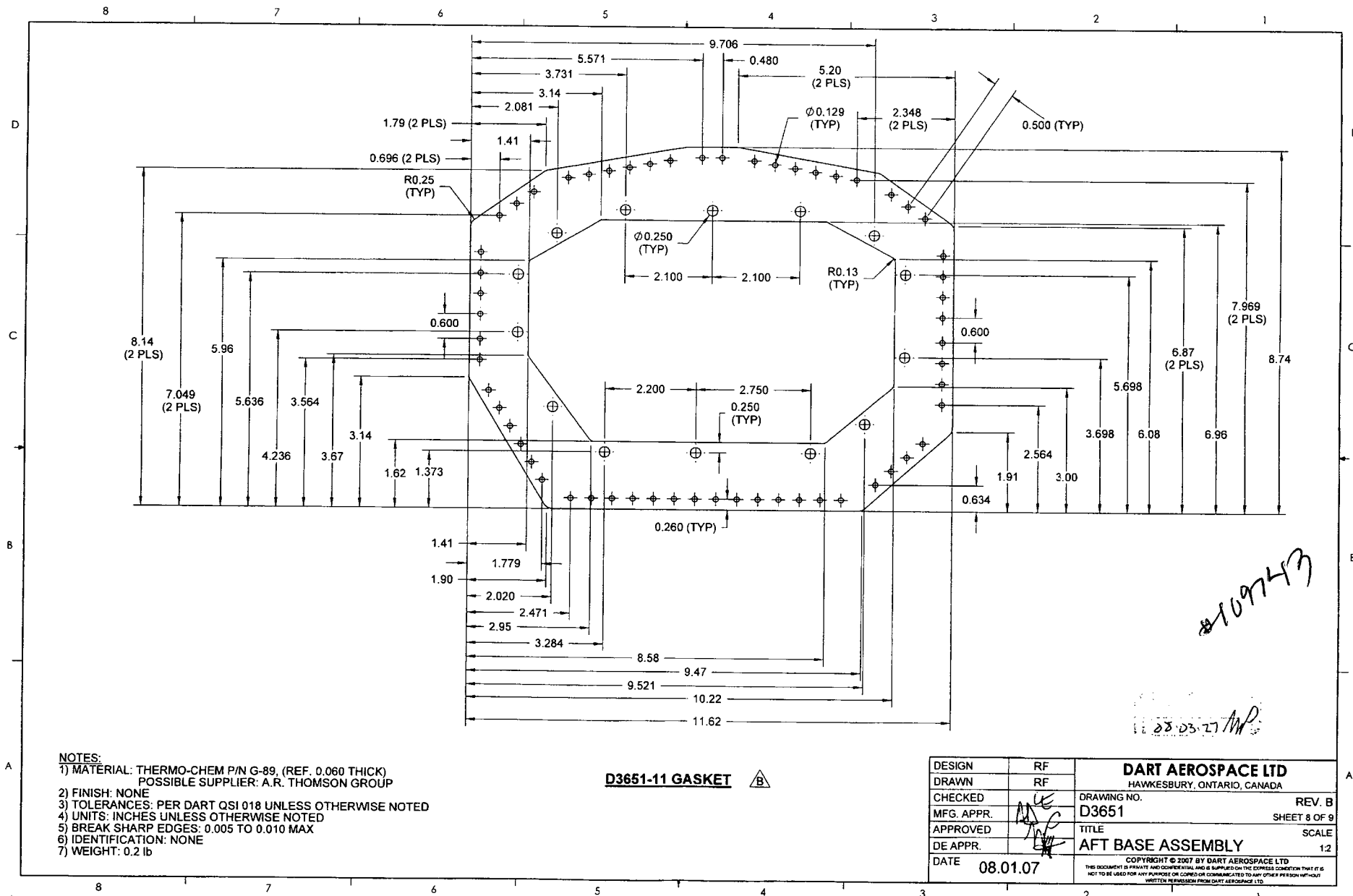


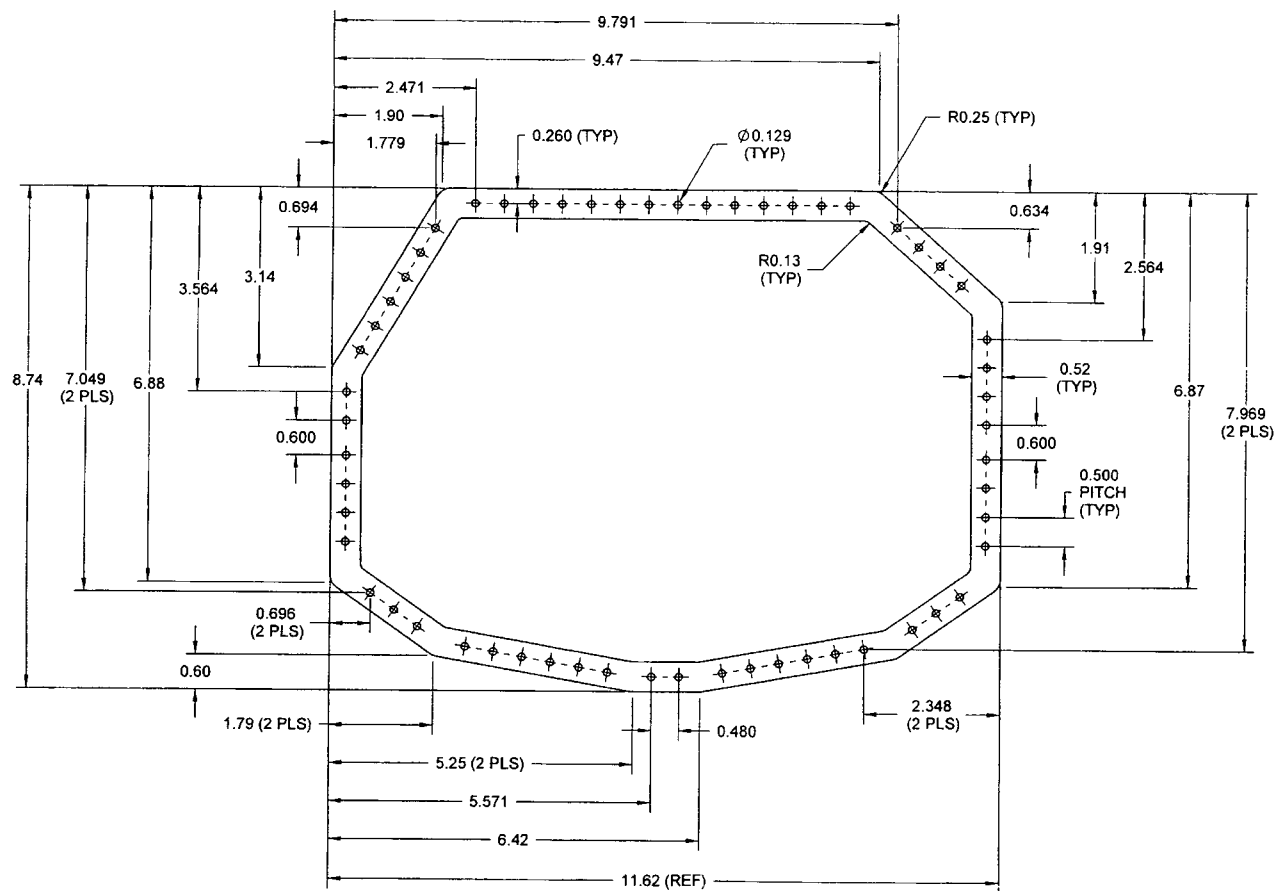
D3651-9 INSIDE DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	WLE	DRAWING NO.	REV. B
MFG. APPR.	WLE	D3651	SHEET 7 OF 9
APPROVED	WLE	TITLE	SCALE
DE APPR.	WLE	AFT BASE ASSEMBLY	1:2
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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





D3651-13 OUTSIDE DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3651	SHEET 9 OF 9
APPROVED		TITLE	SCALE
DE APPR.		AFT BASE ASSEMBLY	1:2
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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Work Order ID 94016 -2 *Spl*

November-29-12 1:39:50 PM

94016

109743

Page 1

Item ID: D3651-043

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Flange Weldment

Start Date: 29/11/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 06/12/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: *MLJ*

Date: 12-11-29 Tooling:

Date:

Stop *NR2*

QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3651	Rev B								
100		0.00							
100	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Weld assembly as per dwg D3651 <i>122357</i>								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

9

R 13-3-12

13

13-03-12

13

13-03-12

*DAS
09
2.89*

*DAS
09
2.89*

Work Order ID 94016

November-29-12 1:39:50 PM

94016

Page 2

Item ID: D3651-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Flange Weldment

Start Date: 29/11/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 06/12/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Small Fab

Small Fab

Memo

0.00

0.00

Small Fab

Assemble as per dwg D3651

140

140

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Quality Control

150

150

Packaging

Identify as per dwg & Stock Location: _____

Memo

0.00

0.00

Packaging

Picklist Print

Page 1

November-29-12 1:39:54 PM

Work Order ID: 94016

94016

Parent Item: D3651-043

D3651-043

Parent Item Name: Flange Weldment

Start Date: 29/11/2012

Required Date: 06/12/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC
IPP Rev:B ECN 1113P 08-01-22 DD
IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3651-5 *D3651-5*		Manufactured	No			100	Each	0.0000	1	2			
Top Flange													
D3651-7 *D3651-7*		Manufactured	No			100	Each	0.0000	1	2			
Bottom Flange													
CR3523-4-02 *CR3523-4-02*		Purchased	No			130	Each	1.002.000	57	114			
RIVET													

Location	Loc Qty	Loc Code
GA	60	
121114	60	
ST312	626	
123164	626	
ST330	316	
116893	3	
116915	1	
120308	100	
120422	15	
120873	197	

D3651-3 Manufactured No

D3651-3

Base

Location	Loc Qty	Loc Code
GA	1	
69548	1	

Picklist Print

November-29-12 1:39:54 PM

Page 2

Work Order ID: 94016

Parent Item: D3651-043

Parent Item Name: Flange Weldment

94016

D3651-043

Start Date: 29/11/2012

Required Date: 06/12/2012

Start Qty: 2.00

Required Qty: 2.00

MS20427M3-3

Purchased

No

130

Each

1,473.000

16

32

MS20427M3-3

**

Rivet

Location

Loc Qty

Loc Code

GA

1318

123352

1318

ST335

155

120930

3

121114

140

123021

12

MS21060-3K

Purchased

No

130

Each

139.0000

8

16

MS21060-3K

**

Nut Plate

Location

Loc Qty

Loc Code

ST302

46

116857

17

117423

13

117977

15

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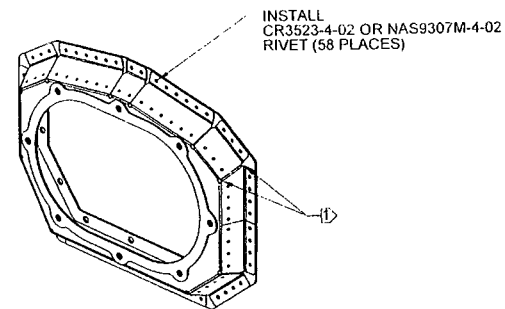
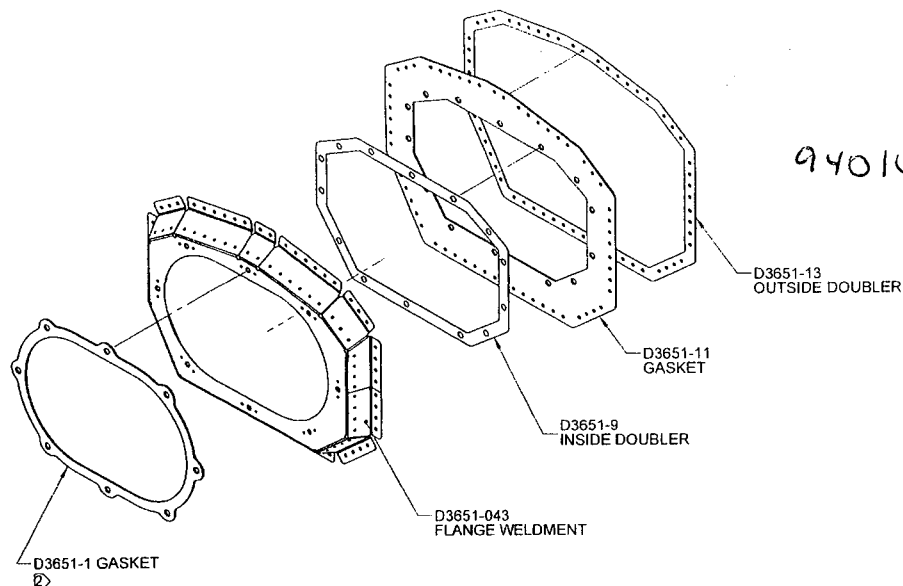
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November-29-12 1:39:54 PM

Shop Packet Print

Page 2



PART LIST

QTY	PART NUMBER	DESCRIPTION
-041		
X	D3651-041	AFT BASE ASSEMBLY
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

D3651-041 AFT BASE ASSEMBLY

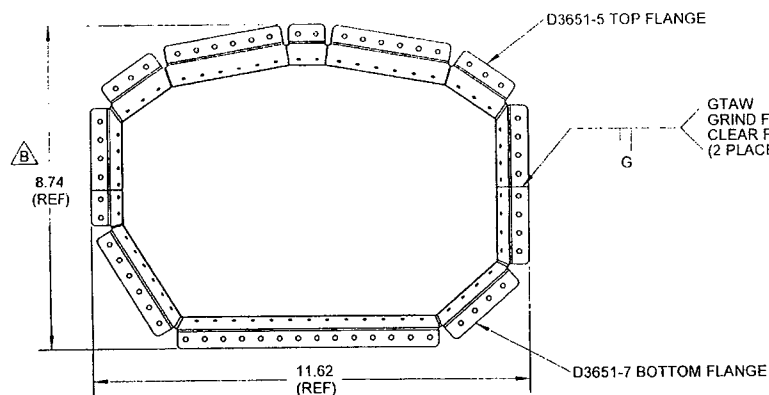
D3651-041 NOTES:

- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.6 lbs

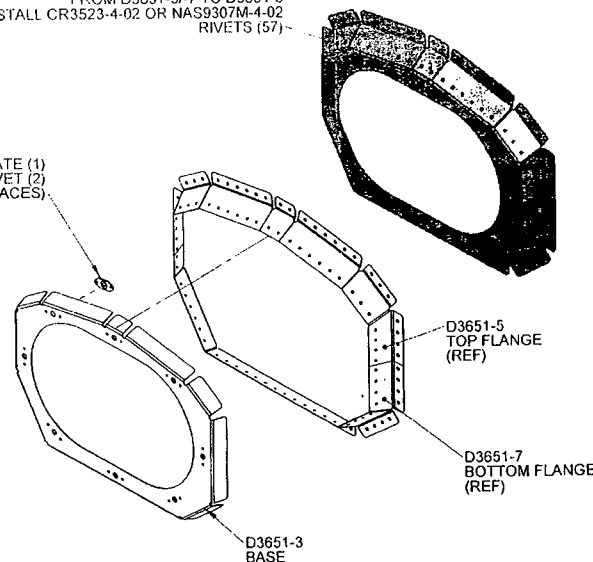
B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50; 0.88 WAS 0.98; REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3651	SHEET 1 OF 9
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	AFT BASE ASSEMBLY	1:4
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TRANSFER DRILL ϕ 0.129 (#30 DRILL)
FROM D3651-5/7 TO D3651-3
INSTALL CR3523-4-02 OR NAS9307M-4-02
RIVETS (57)



D3651-043 FLANGE WELDMENT



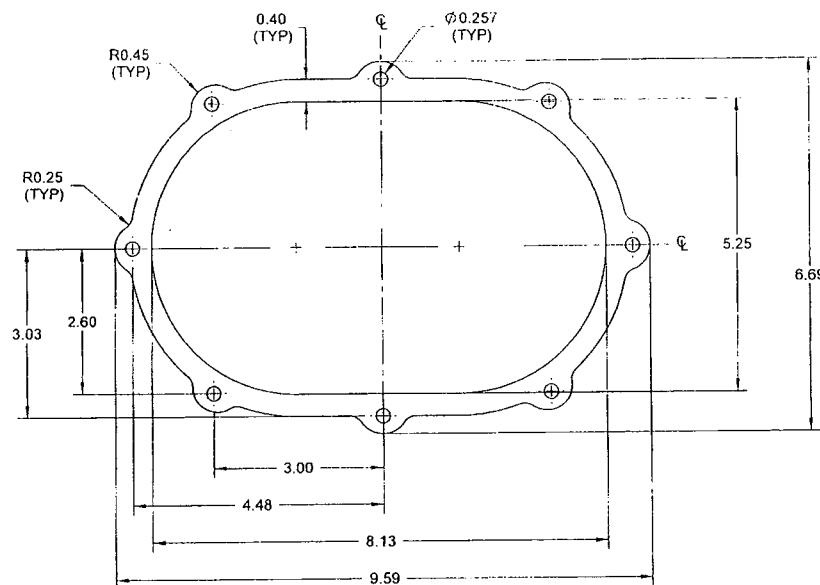
QTY -043	PART NUMBER	DESCRIPTION
X	D3651-043	FLANGE WELDMENT
1	D3651-3	BASE
1	D3651-5	TOP FLANGE
1	D3651-7	BOTTOM FLANGE
16	MS20427M3-3	RIVET
8	MS21060-3K	NUTPLATE
57	CR3523-4-02 or NA9307M-4-02	RIVET

D3651-043 NOTES:

- 1) WELD PER QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.76 lbs

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MFG. APPR.	ME	TITLE AFT BASE ASSEMBLY	SHEET 2 OF 9
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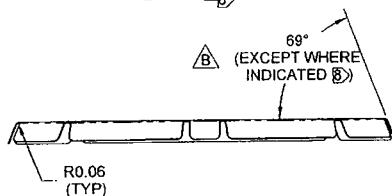
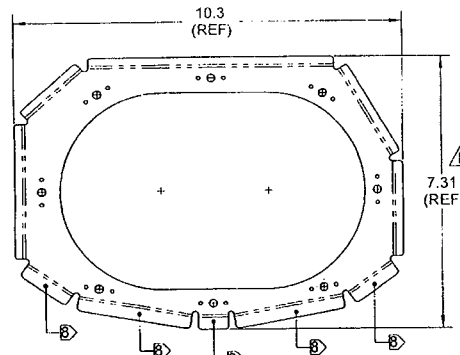
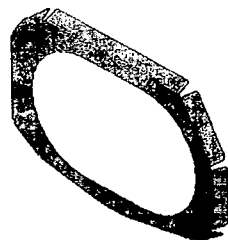
D3651-1 GASKET

NOTES:

- 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) PART IS SYMMETRIC ABOUT ϕ
- 8) WEIGHT: 0.09 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	RF	D3651	SHEET 3 OF 9
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DE APPR.	RF	AFT BASE ASSEMBLY	1:2
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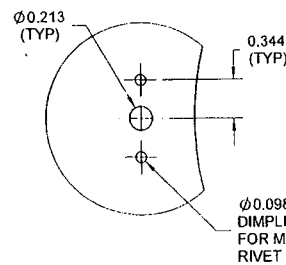
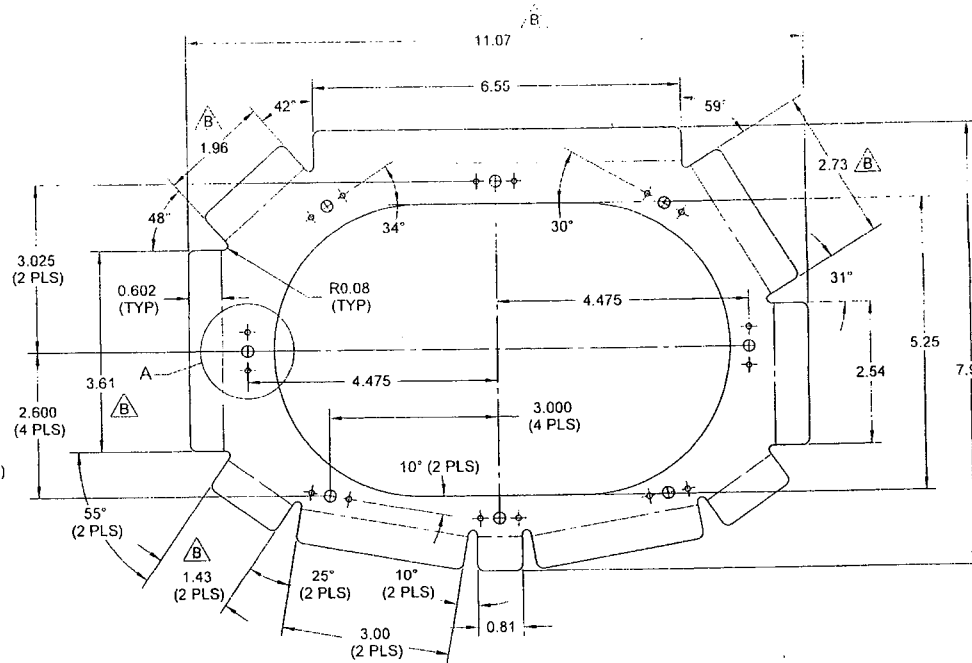
94016



D3651-3 BASE
(MAKE FROM D3651-3F FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs
- 8) BEND TO 55° WHERE INDICATED



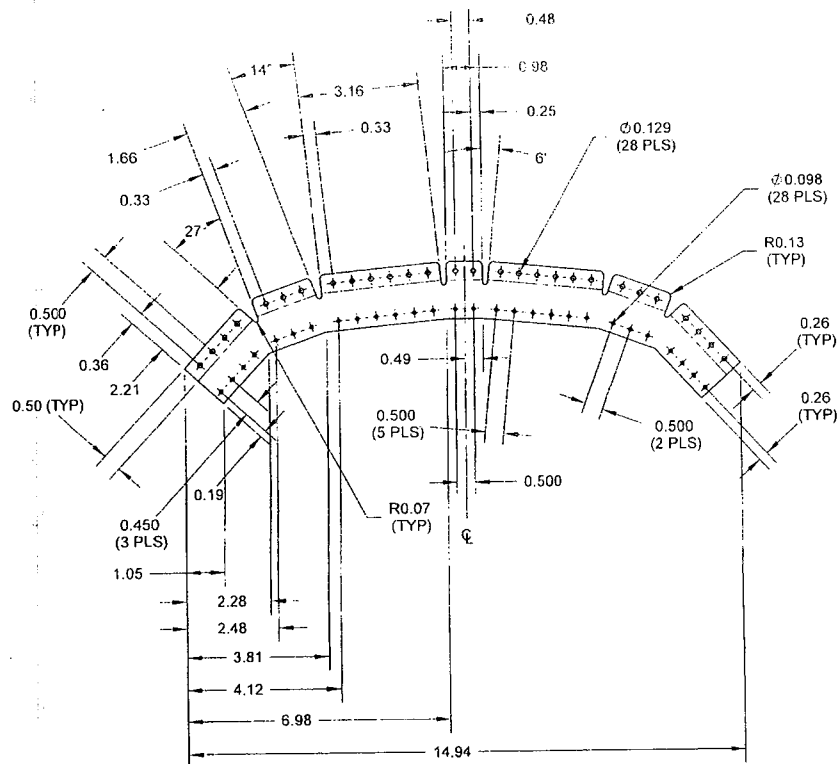
DETAIL A

D3651-3F FLAT PATTERN

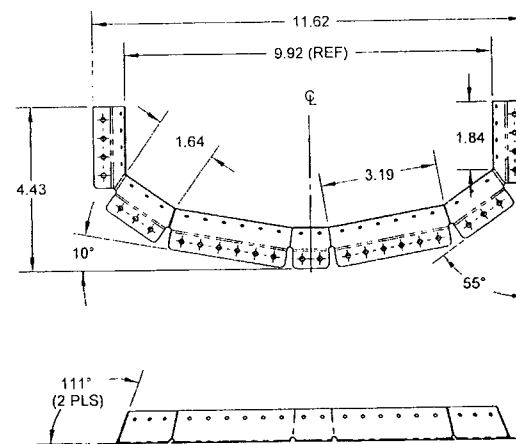
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CE	DRAWING NO. D3651	REV. B
MFG. APPR.	ME	SHEET 4 OF 9	
APPROVED	ME	TITLE	SCALE
DE APPR.		AFT BASE ASSEMBLY	
DATE	08.01.07	1:2	

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D3651-5F FLAT PATTERN B



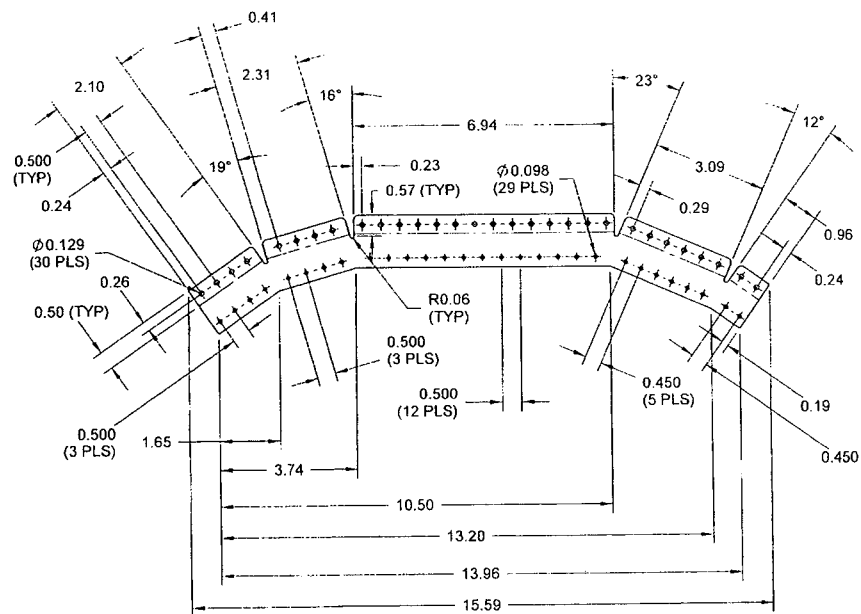
D3651-5 TOP FLANGE BEND DETAIL
(MAKE FROM D3651-5F FLAT PATTERN) B

NOTES:

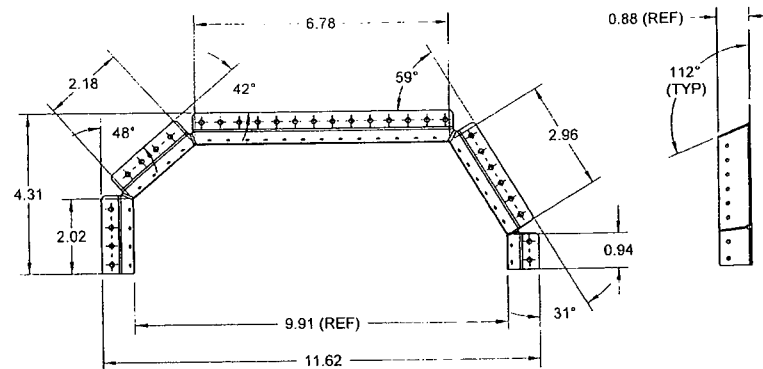
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3651	SHEET 5 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AFT BASE ASSEMBLY	1:3
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D3651-7F FLAT PATTERN



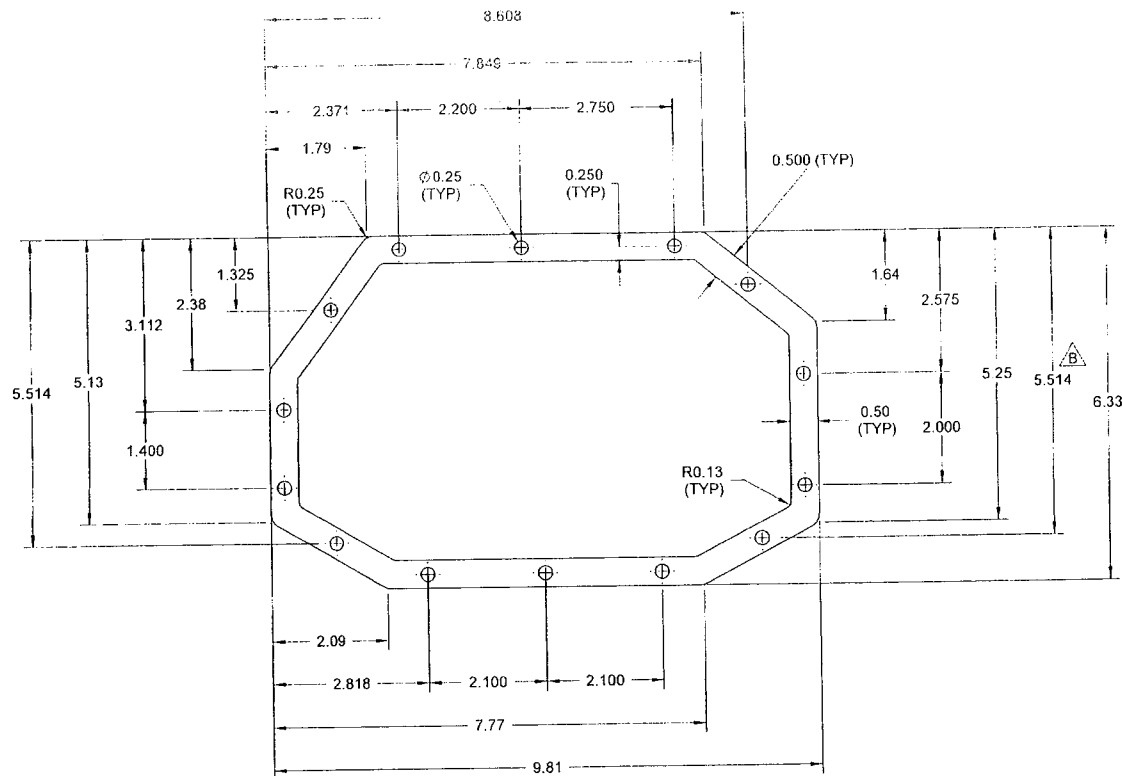
D3651-7 BOTTOM FLANGE BEND DETAIL
(MAKE FROM D3651-7F FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

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D3651-9 INSIDE DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	WKE	DRAWING NO.	REV. B
MFG. APPR.	WKE	D3651	SHEET 7 OF 9
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NOTES:

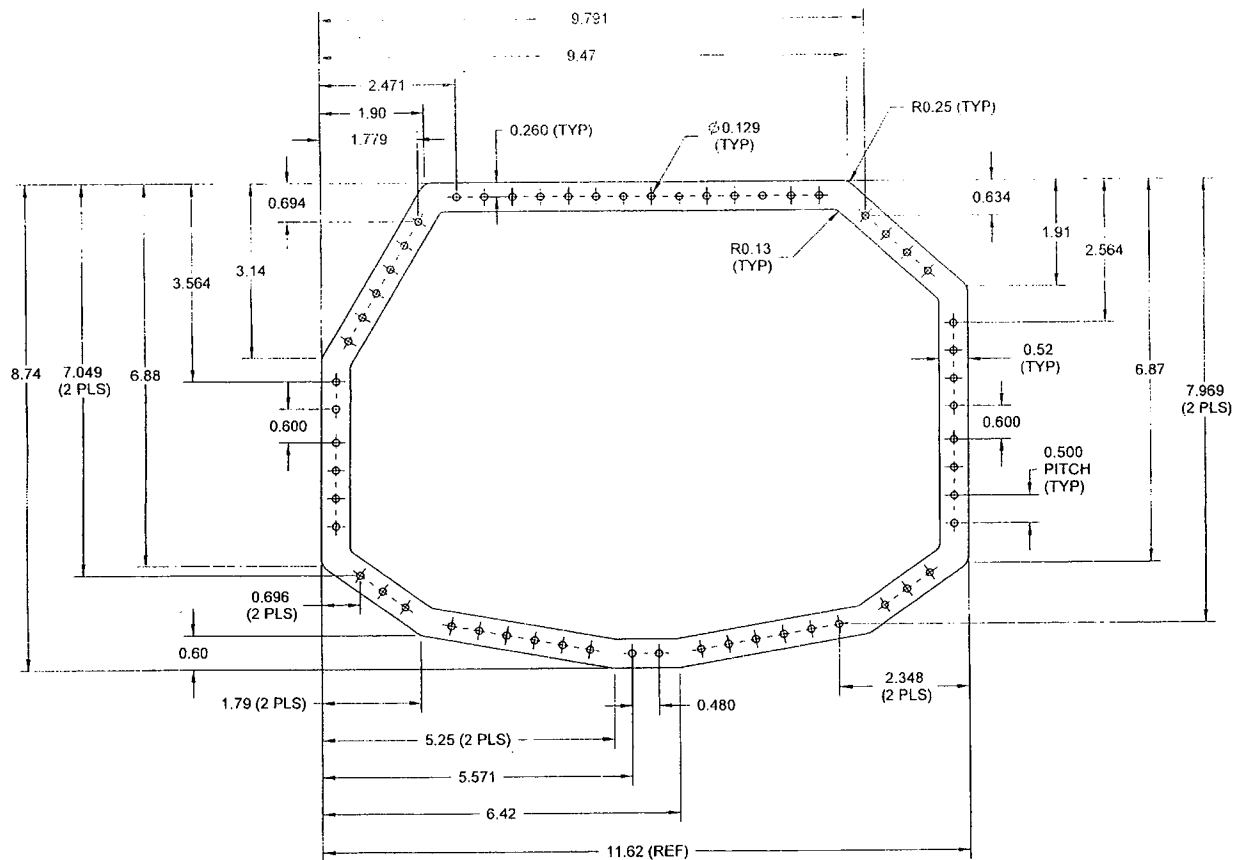
- 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.2 lb

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	RF	DART AEROSPACE LTD	
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CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D3651	SHEET 8 OF 9
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D3651-13 OUTSIDE DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ME	DRAWING NO.	REV. B
MFG. APPR.	ME	D3651	SHEET 9 OF 9
APPROVED	ME	TITLE	SCALE
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